

**Work Order ID 55222**

January 12, 2010 1:27:21 PM



Page 1

Item ID: D4043-041

Accept



Setup Start



Revision ID:

Item Name: Fwd Rib Assembly

Stop



Start Date: 1/12/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-1-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	Memo	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
D4043	PA1 PA3 10-1-12	Weld per dwg A/R S.S. rod Batch: M109213	0.00							
100										
Large Fab										

**MATERIAL CERTIFICATION**  
**REQ'D UPON DELIVERY**

Large Fab

Large Fab

- Memo
- 1- Cut as per dwg D4043-1
  - 2- Drill and chamfer holes as per dwg D4043-1
  - 3-remove identification markings
  - 4- Weld bushing in rib and grind weld flush as per dwg D4043

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 55222**

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January 12, 2010 1:27:21 PM

Item ID: D4043-041

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

120



QC

Quality Control

Operation  
Description

QC10- Inspect visual per QSI004- ground welds

Set Up/  
Run Hours

0.00

Draw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

=&gt; S\_10.01.20

130



Packaging

Packaging

Identify as per dwg &amp; Stock Location: basket

0.00

PD 10.01.21 ①

Memo

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

JH- Prototype test  
10.01.30

MF 10-1-21

POSITIVE RECALL

EFFECTIVE \_\_\_\_\_ AUTH \_\_\_\_\_

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Picklist Print**

Page 1

January 12, 2010 1:27:29 PM

Work Order ID: 55222



Parent Item: D4043-041



Parent Item Name: Fwd Rib Assembly

Start Date: 1/12/10

Required Date: 1/25/10

Comments: IPP RevA: new issue DD 10/01/05 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4043-9		Manufactured	No			100	Each	0.0000	1.0000		B55255	PD 10.01.20
Bushing	M304TS0.500W.049	Purchased	No			100	f	79.3900	2.2518			
Square Tubing												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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Location

Main Warehouse

MAT	79.39	
113303	79.39	

H  
M109087

PD 10.01.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

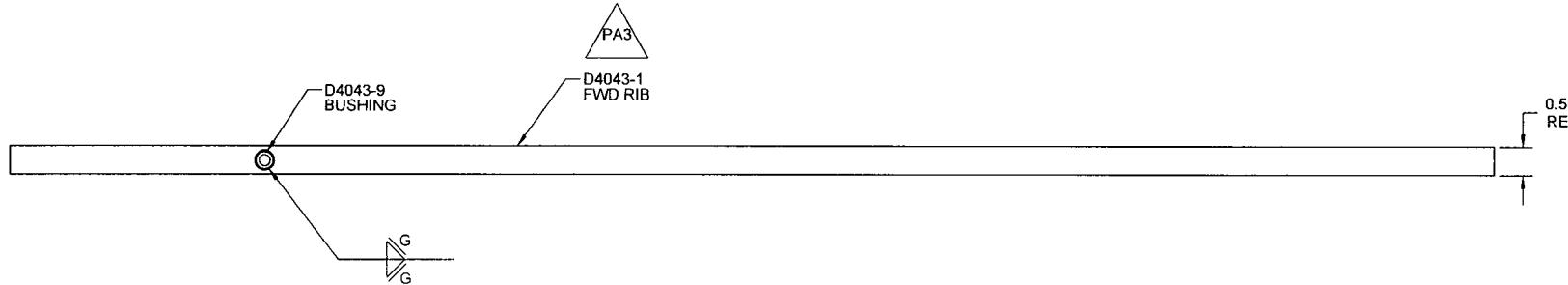
D

C

C

B

B



D4043-041 RIB ASSEMBLY

**PRELIMINARY ISSUE**

 10.01.18

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.60 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. REV. PA3	
MFG. APPR.		D4043	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSEMBLY	NTS
DATE	10.01.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY INFORMATION AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

A

A

## Receiving Report

Date: 8/12/02

Batch No: M109687

Supplier: MAGNA

Dart P/O: 7019

Packing Slip: Yes  No   
 Invoice: Yes  No   
 Receipt: Cash  Cr

Release Note Attached: Yes  No  N/A   
 Waybill Attached: Yes  No  N/A   
 Shipment Complete: Yes  No  N/A   
 QC6 Inspection: OK Yes  No  N/A   
 Work Order: OK Yes  No  N/A

### Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 JL

Production/Admin:

Date: 08/09/02

Received/Costing

Initial: RCP 8763

Location:

# MAGNA

INOXYDABLE

Magna Stainless division de CSM Inc.

525 Meloche Ave., Dorval (Québec) H9P 2W2

Tél.: (514) 631-1211 • Fax: (514) 631-0013

Sans frais/Toll free: 1-800-363-6646

**ISO 9001-2000**

N° FACTURE / INVOICE NO.

164382

VENDU À - SOLD TO  
 DART  
 DART AEROSPACE LTD  
 1270 ABERDEEN STREET  
 HAWKESBURY  
 ONTARIO  
 K6A 1K7

EXPÉDIÉ À - SHIPPED TO

MEME - SAME

DATE	N° LIVR. - DEL. NO.	PAR - VIA	N° COMM. DU CLIENT CUST. ORDER NO.	CONDITIONS - TERMS	N° T.V.Q. - Q.S.T. NO.	N° T.P.S. - G.S.T. NO.	
Aug29/08	0174394	NIR-R-557065-1	7019		1213236471	881565899 RT0001	
QTÉ EXP. QTY SHIPPED	DESCRIPTION			POIDS EXPÉDIÉ WEIGHT SHIPPED	PRIX - PRICE	UNITÉ UNIT	TOTAL
304 180 GRIT							
5 3/4" SQ 18GA X 20'					28.00	PCS	140.00
HEAT TUYU238460							
Heat # 174394							
SHIPPED WITH 174638							

**Dart Aerospace Ltd**

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawsbury, Ontario K6A 1K7  
Phone: (613) 632-3336  
Fax: (613) 632-4443

**Receiving Slip**

Date Sep 2, 2008	Page 1
Receipt Number RCP00008763	

**Purchase From:**

Magna Stainless  
525 avenue Meloche  
Dorval, QC H9P 2W2  
Canada

**Ship To:**

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawsbury, Ontario K6A 1K7

Reference	Description	Contact	Vendor Number	PO Number
			VC-MAG002	PO00007019

Vendor Item Number	Item Number	Description	Qty. Received	UOM	Unit Cost	Extended Cost	Arrival Date
	M304TS0750W049	304 SQ Tube .75x.75x. MATERIAL: AISI 304/316 SS SQUARE TUBING B/N109087	100.0000	f	1.400000	140.00	Sep 02, 2008

**Comments:**

**MAGNA**  
INDUSTRIAL

MAGNA STAINLESS DIV. DE CSM INC.  
525 MELOCHE AVE.  
DORVAL, QUEBEC H9P 2W2  
(514) 631-1211 FAX: (514) 631-0013

COMMANDÉ  
SALES ORDER

0174394

DU À /  
SHIP TO:

LIVRÉ À /  
SHIP TO:

DART AEROSPACE LTD  
270 ABERDEEN STREET  
HAWKESBURY  
ONTARIO

K6A 1K7

INSTRUCTIONS SPÉCIALES / SPECIAL INSTRUCTIONS

REF. DE LA COMMANDE / SALES ORDER NO.	CODE DE CLIENT / CUSTOMER CODE	BON D'ACHAT DU CLIENT / CUSTOMER PURCHASE ORDER	N° DE TÉLÉPHONE DU CLIENT / CUSTOMER TELEPHONE NUMBER	N° DE TÉLÉCOUREUR DU CLIENT / CUSTOMER FAX NO.
0174394	DART	7019	613 632-5200	632-1053
DUPLIQUÉ VIA / SHIP VIA	CONDITIONS D'EXPÉDITION / SHIPMENT TERMS	DATE COMMANDEE / DATE ORDERED	DATE REQUISE / DATE REQUIRED	DATE EXPÉDIÉE / DATE DELIVERED
NIR:R-557065-1	NET 30	Aug-26-08	Aug-29-08	15 26 EB
CONTROLE DE QUALITE DU CLIENT / CUSTOMER QUALITY RELEASE REQ'D	CONTROLE DE QUALITE DE MAGNA RÉGULE / MAGNA QUALITY RELEASE REQ'D	PREPARE / PREPARED	REÇU PAR / COLLECTED	
QUALITE DU PRODUIT / PRODUCT QUALITY	UNITE / UNIT	NO. DE COULEE / HEAT NUMBER	QTE LIVREE / QTY SHIPPED	PRIS PAR / PRICE PER
COMMANDE / ORDER				INSTRUCTIONS DE L'USINE / PLANT INSTRUCTIONS
5	PCS	TUYU2384	100/474	5 pcs CK358 F8/09
TOTAL : LBS				

IBRE DE PAQ.  
NUMBER OF BOXES

MTR-AVEC COMMANDE  
MTR'S-WITH ORDER

POSTE  
MAIL  TÉLÉSCOUREUR  
PAX

ge: 1

11:28:12

20080826

N° DE COULEE ÉTAMPER SUR LE CÔTÉ  
HEAT NO. STAMP ONE END

\*\*PACKING SLIP / BON D'EMBALLAGE\*\*

MATERIEL REÇU EN BON ÉTAT PAR / MATERIAL RECEIVED IN GOOD CONDITIONS BY:

REVISION 'E' - 07/07 - FORM 8008



WINNER STAINLESS STEEL TUBE CO., LTD

ORIGINAL



ADDRESS: 3RD INDUSTRIAL PARK, XIAOBU VILLAGE, HUASAN  
TOWN, HUADU DISTRICT, GUANGZHOU, P.R.C.  
TEL: +86-20-86847851 FAX: +86-20-86941744

## MILL TEST CERTIFICATE

Customer:

Issued Date: 2006/10/12

Order No.: 119

Certificate No.: GUL-F684

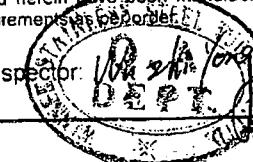
Article: Stainless steel mechanical structures welded tube						Specification: ASTM A554-03							
Item No.	Size	Length	Qty,Pcs	Net Weight	Type	Heat No.	Annealed Temperature (°F)		Hold Time (minute)	Cooling	Surface Finish	Hydrostatic Test (psi)	ET
6~7#	3/4"SQx18GA	20'	200	816.86	MT304	TU-YU238460	—	—	—	—	180Grit	—	—
8#	3/4"SQx18GA	20'	48	196.05	MT304	TU-YU238460	—	—	—	—	180Grit	—	—
9~12#	3/4"SQx16GA	20'	400	2145.80	MT304	TU-YU238951	—	—	—	—	180Grit	—	—
13#	3/4"SQx16GA	20'	27	144.84	MT304	TU-YU238951	—	—	—	—	180Grit	—	—
14#	3/4"SQx16GA	20'	19	101.93	MT304	TU-YU142400	—	—	—	—	180Grit	—	—
Chemical Composition (%)								Mechanical Test					
	C	Mn	P	S	Si	Ni	Cr	Mo	T. S. (Ksi)	Y. S.(Ksi)	Elongation(%)	Flattening	
MIN						8.00	18.00	—	≥75	≥30	≥35	≤2/3D	
MAX	0.080	2.00	0.040	0.030	1.00	11.00	20.00	—					
6~7#	0.025	1.49	0.038	0.004	0.47	8.08	18.14	—	95	51	52	good	
8#	0.025	1.49	0.038	0.004	0.47	8.08	18.14	—	95	51	52	good	
9~12#	0.026	1.44	0.031	0.005	0.36	8.09	18.29	—	99	49	55	good	
13#	0.026	1.44	0.031	0.005	0.36	8.09	18.29	—	99	49	55	good	
14#	0.023	1.41	0.035	0.007	0.44	8.09	18.21	—	92	50	51	good	

Remarks:

1. Corrosion test: as per ASTM-A262, Practice E: accepted.
2. Dimensions & Visual: good.
3. Materials are free from mercury contamination.

We, Winner Stainless Steel Tube Co., Ltd., hereby certify that the products described herein have been manufactured in accordance with the standards and specifications specified as above and meet the requirements as per order.

Q. C. Manager/Work Inspector:



536193/536194/536195



## Purchase Order

Date	Page
Aug 25, 2008	1
<b>Purchase Order Number</b>	
PO00007019	

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawkesbury, Ontario K6A 1K7  
Phone: (613)632-9577  
Fax: (613)632-1053

**Vendor Address:**

**Magna Stainless**  
525 avenue Meloche  
Dorval, QC H9P 2W2  
Canada  
Phone (800) 363-6646  
Fax (514) 631-0013

**Ship To:**

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawsbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-MAG002	Aug 25, 2008	N30 yours		Aug 26, 2008

MATERIAL CERTIFICATION  
REQD UPON DELIVERY

M 108-57  
M 108-087

Comments:	Tax Summary:		
	GST	179.70	
	ONTPST	0.00	
	Entered By: CL	CLAVOIE	
	Approved By:		